

Work Order ID 128806

128806

Page 1

Tuesday, January 27, 2015 7:48:29 AM

Item ID: D412-694-115 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Window
 Start Date: 1/16/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-01-28 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
DSI 9715	A	<u>SP</u>

MLJ 15-05-07

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy Bluefiles and create labels per PPP D412-694-115 CHG001								

DAS 6 9-89 MAY 12 2015

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAS 26 9-89 DAS 27 9-89 MAY 07 2015

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 6 9-89 MAY 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128806

Tuesday, January 27, 2015 7:48:29 AM

128806

Page 2

Item ID: D412-694-115

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Window

Stop ***NS2***

Start Date: 1/16/15 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 1/26/15 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00					DAS		
130						4	6		
Packaging	Memo	0.00					989		MAY 12 2015
Packaging	Identify and pack for shipping as per PPP D412-694-115								
	Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				MCS			MAY 13 2015
Quality Control									

MCS MAY 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
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Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, January 27, 2015 7:48:29 AM

Page 1

Work Order ID: 128806

128806

Parent Item: D412-694-115

D412-694-115

Parent Item Name: Replacement Window

Start Date: 1/16/15

Required Date: 1/26/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 15.02.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3136-045		Manufactured	No				Each	1.0000					
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~~*D3136-045*~~

Window Assembly

DAS
6
9-89

Location

Loc Qty

Loc Code

ST435

1

128284

1

Each

6.0000

** T. B128916

DAS
26
27
9-89

D3237-1-0980

Manufactured No

~~*D3237-1-0980*~~

Seal-98"

DAS
6
9-89

DAS
38
9-89

Location

Loc Qty

Loc Code

ST422a

6

128302

6

Each

6.0000

** B128283

DAS
26
27
9-89

D3237-3-0980

Manufactured No

~~*D3237-3-0980*~~

Seal-98"

DAS
6
9-89

DAS
38
9-89

Location

Loc Qty

Loc Code

ST422a

6

128303

6

** B123981

DAS
26
27
9-89

MAY 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
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Material									
Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-694 REV B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-694 REV 1
REF TCCA STC: SH05-10
REF FAA STC: SR02086NY
REF EASA STC: EASA.IM.R.S.01085

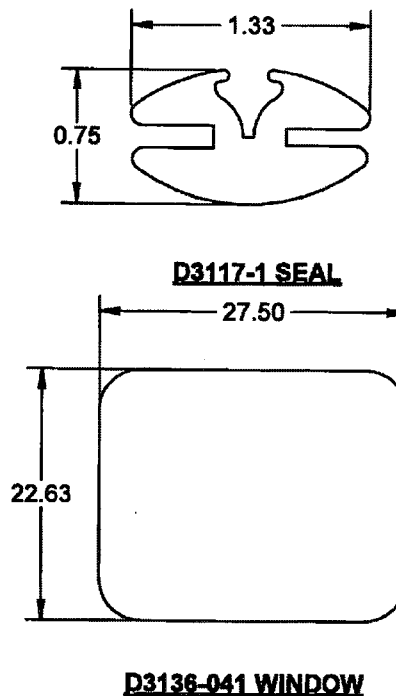
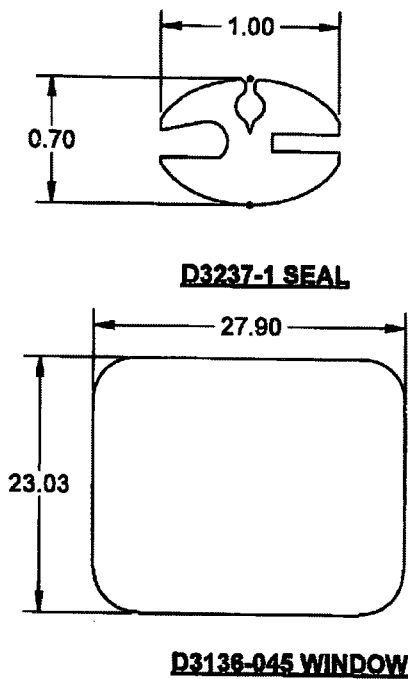
128806MCS
1501-28

1.0 PURPOSE

On D412-694-011 Spacedoor Installations at CHG 005 and later, the D412-694-015 Replacement Window Kit has been replaced with D412-694-115 Replacement Window Kits. The D3117-1-0980 Seal Retainer, D3117-3-0980 Seal Filler and D3136-041 Window Assembly have been replaced by a D3237-1-0980 Seal Retainer, D3237-3-0980 Seal Filler and D3136-045 Window Assembly. Operators with D412-694-011 Spacedoors at CHG 004 or earlier with the D3117-1/-3 Seal in working condition may still order the D3136-041 Window as a replacement. Operators needing to replace the D3117-1/-3 Seal must order a complete D412-694-115 Replacement Window Kit (seal and window) and should update the Aircraft Log Book to record the change to the new window and seal.

2.0 INSTALLATION

Installation procedure for the D412-694-115 Replacement Window Kit is identical to the Installation of the D412-694-015 Window Kit (Section 3.4) of IIN-D412-694. The following diagram shows the differences between the D3117-1 Seal and the D3237-1 Seal and the differences between the D3136-041 and D3136-045 windows.



NOTE: D3136-041 Windows are **NOT** compatible with D3237-1 Seals and D3136-045 Windows are **NOT** compatible with D3117-1 Seals

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.12.11
CERT. NO.: SH05-10
ISSUE NO.: 1

A	NEW ISSUE	DB	14.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSI 9715 TITLE REPLACEMENT WINDOW KIT COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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CHECKED	N/A		
MFG. APPR.			
APPROVED			
DE APPR.		REV. A	
DATE	14.12.11	SHEET 1 OF 2	
		SCALE NTS	

3.0 MAINTENANCE

Maintenance of the D412-694-115 Replacement Window Kit shall be in accordance with ICA-D412-694 Rev 1.

4.0 WEIGHT AND BALANCE

There is no change to weight and balance associated with the use of the D412-694-115 Replacement Window Kit in lieu of the D412-694-015 Replacement Window Kit.

5.0 PARTS LIST

The parts list of IIN-D412-694 and ICA-D412-694 for D412-694-011 at CHG 005 or later is amended as follows;

IS

QTY -011	QTY -115	QTY -01	QTY -02	QTY -03	QTY -04	PART NUMBER	DESCRIPTION
X						D412-694-011	SPACEDOOR INSTALLATION
4	X					D412-694-115	REPLACEMENT WINDOW KIT
1		X				D412-694-01	DOOR ASSEMBLY
1			X			D412-694-02	DOOR ASSEMBLY
1				X		D412-694-03	DOOR ASSEMBLY
1					X	D412-694-04	DOOR ASSEMBLY
	1					D3136-045	WINDOW ASSEMBLY
	1					D3237-1-0980	SEAL RETAINER
	1					D3237-3-0980	SEAL FILLER

WAS

QTY -011	QTY -015	QTY -01	QTY -02	QTY -03	QTY -04	PART NUMBER	DESCRIPTION
X						D412-694-011	SPACEDOOR INSTALLATION
4	X					D412-694-015	REPLACEMENT WINDOW KIT
1		X				D412-694-01	DOOR ASSEMBLY
1			X			D412-694-02	DOOR ASSEMBLY
1				X		D412-694-03	DOOR ASSEMBLY
1					X	D412-694-04	DOOR ASSEMBLY
	1					D3136-041	WINDOW ASSEMBLY
	1					D3117-1-0980	SEAL RETAINER
	1					D3117-3-0980	SEAL FILLER

DESIGN	DB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. DSI 9715	REV. A SHEET 2 OF 2
DRAWN	DB				
CHECKED	N/A				
MFG. APPR.					
APPROVED					
DE APPR.				TITLE REPLACEMENT WINDOW KIT	SCALE NTS
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3.0 MAINTENANCE

Maintenance of the D412-694-115 Replacement Window Kit shall be in accordance with ICA-D412-694 Rev 1.

4.0 WEIGHT AND BALANCE

There is no change to weight and balance associated with the use of the D412-694-115 Replacement Window Kit in lieu of the D412-694-015 Replacement Window Kit.

5.0 PARTS LIST

The parts list of IIN-D412-694 and ICA-D412-694 for D412-694-011 at CHG 005 or later is amended as follows;

IS

QTY -011	QTY -115	QTY -01	QTY -02	QTY -03	QTY -04	PART NUMBER	DESCRIPTION
X						D412-694-011	SPACEDOOR INSTALLATION
4	X					D412-694-115	REPLACEMENT WINDOW KIT
1		X				D412-694-01	DOOR ASSEMBLY
1			X			D412-694-02	DOOR ASSEMBLY
1				X		D412-694-03	DOOR ASSEMBLY
1					X	D412-694-04	DOOR ASSEMBLY
	1					D3136-045	WINDOW ASSEMBLY
	1					D3237-1-0980	SEAL RETAINER
	1					D3237-3-0980	SEAL FILLER

WAS

QTY -011	QTY -015	QTY -01	QTY -02	QTY -03	QTY -04	PART NUMBER	DESCRIPTION
X						D412-694-011	SPACEDOOR INSTALLATION
4	X					D412-694-015	REPLACEMENT WINDOW KIT
1		X				D412-694-01	DOOR ASSEMBLY
1			X			D412-694-02	DOOR ASSEMBLY
1				X		D412-694-03	DOOR ASSEMBLY
1					X	D412-694-04	DOOR ASSEMBLY
						D3136-041	WINDOW ASSEMBLY
						D3117-1-0980	SEAL RETAINER
						D3147-3-0980	SEAL FILLER

DESIGN DB
DRAWN DB
CHECKED
MFG. APPR. N/A
APPROVED
DE APPR.
DATE 14.12.11

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. DSI 9715
TITLE REPLACEMENT WINDOW KIT
REV. A
SHEET 2 OF 2
SCALE NTS

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